



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE703A95-0508-00

Job Sheet 170594



001256

Part No: RBE703A95-0508-00

Job Qty: 6 ea

Part Name: Main Rotor Gear Box Drain Tube



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP Rev A 17.11.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/27/18	0.00	0.00	Start Up Small Fab-2		MCC
110	Small Fab	6 pcs		2/27/18	0.00	6.00	Small Fab		MCC
120	QC	6 pcs		2/27/18	0.00	0.00	QC5		GA
130	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging3		MAR 01 2018
140	QC21-SA	6 Ea		2/27/18	0.00	0.00	QC21		18/03/01

Part Op
Descriptions: 110 - Assemble as per DWG. Sheet 1

DAS
21
9-89

MAR 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	2.4000 ft (.4 ea)	90-Start up Operation	
2044T67	Cap Ø1.09	12 Ea (2 ea)	90-Start up Operation	
51495K116	COUPLING 1/2" NCKL PLTD BRASS PUSH TO CONNECT TUBE FITTING COUPLING	6 Ea (1 ea)	90-Start up Operation	
9263K173	O-Ring	6 Ea (1 ea)	90-Start up Operation	
K010-0608	Hose Ø1/2 OD x Ø3/8 ID x 12-1/2ft	42 ft (7 ea)	90-Start up Operation	
PAD210	Foam Ø1 X 1	.0420 sf (.007 ea)	90-Start up Operation	
RBE703A95-0508-00-1 Quill		6 Ea (1 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

DART
AEROSPACE

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Container No: S046436



Part: RBE703A95-0508-00

Job No: 170594

Serial No/Batch: S046436

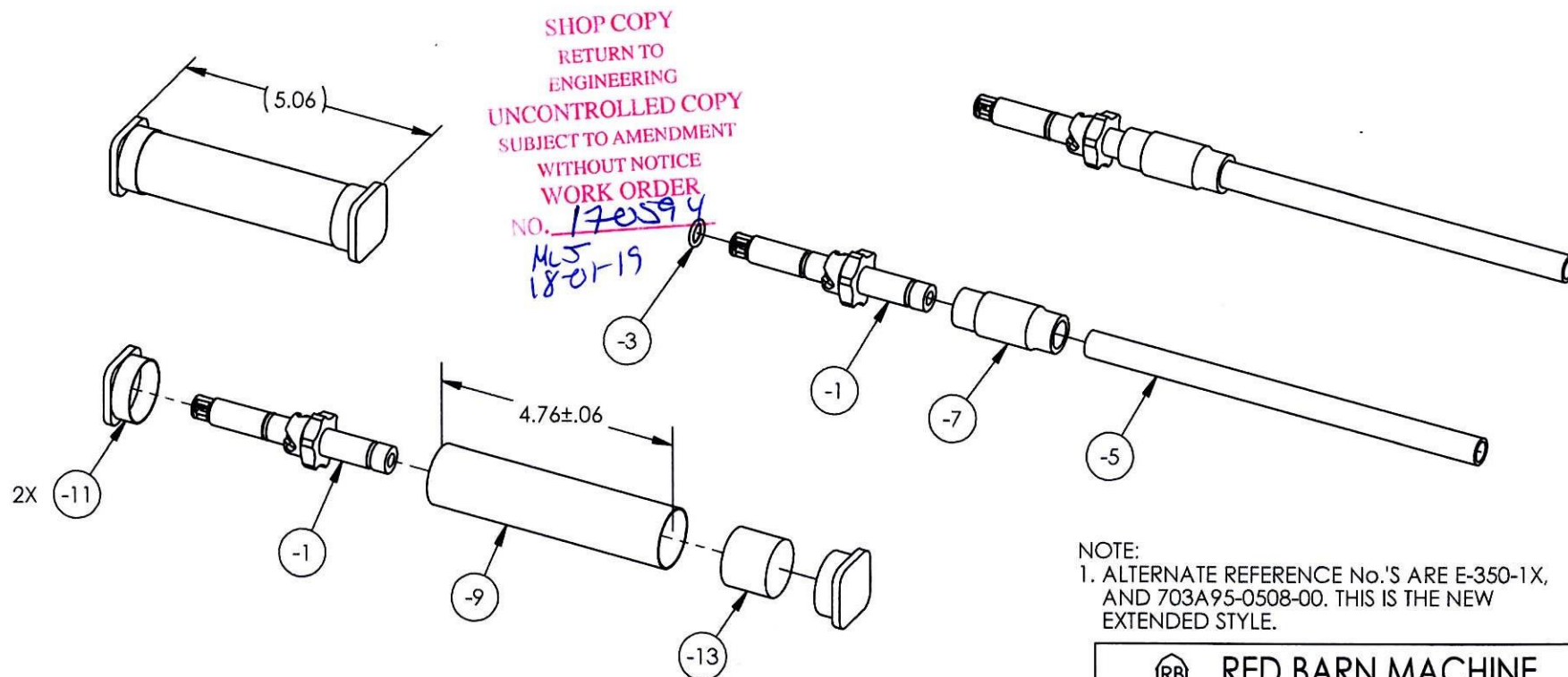
Revision: 5C

Inspector:

Date: 02/28/18

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	CH'D O-RING FROM $\varnothing 13\text{mm}$ OD x 1.75mm cross section. ADDED NOTES, CH'D SLOTS FROM $90^\circ @ \varnothing .131$, AND ID FROM $\varnothing .230$	5/28/2009	WP RW
2	CH'D ID FROM $\varnothing .256$ THRU, CH'D SLOTS FROM $60^\circ @ \varnothing .125$ ON HELIX PER G.E.	11/4/2009	RJC RW
2A	DELETED 20.2" REF. DIMENSION PER G.E.	12/16/2010	RJC RW
3	MODIFIED -1 TO WORK WITH COUPLING, ADDED COUPLING, TUBE, CAPS, AND SPONGE, DELETED HOSE CLAMP.	1/7/2013	JAG
4	CH'D 8X R.156 & 8X .12 TO 6X R.375 & 6X .106.	4/17/2013	CFS GE
5	CH'D T/N WAS RBEA95-0508-00 IS RBE703A95-0508-00. -1 CH'D DIMS WAS 6X .106 IS 6X .11, WAS 6X R .375 IS 6X R .38.	6/19/2013	BIM RW
5A	CH'D TOOL NAME WAS MAIN GEAR BOX DRAIN TOOL IS MGB DRAIN TUBE.	11/7/2013	RJC RW
5B	-9 CH'D DIM WAS 4.86 IS 4.76. -13 CH'D MATERIAL TO NEW PIG CORP. #PAD210.	2/5/2014	DPD RW
5C	-5 CH'D LENGTH OF HOSE WAS 6 FEET IS 7 FEET.	3/26/2014	RJC DW



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	QUILL	6061	$\varnothing 1-1/8 \times 4-1/8$	2
		B/O	-3	1	O-RING	VITON	$\varnothing 13\text{mm}$ O.D. x 2mm WIDTH MCMaster-CARR #9263K173	1
		B/O	-5	1	HOSE	VINYL	$\varnothing 1/2$ O.D. x $\varnothing 3/8$ I.D. x 7ft KURI-TECH #K010-0608	1
		B/O	-7	1	COUPLING	NICKEL-PLATED BRASS	$\varnothing 1/2$ MCMaster-CARR #51495K116	1
		B/O	-9	1	TUBE	POLYETHYLENE	$\varnothing 1.09$ MCMaster-CARR #2044T47	1
		B/O	-11	2	CAP	VINYL	$\varnothing 1.09$ MCMaster-CARR #2044T67	1
		B/O	-13	1	SPONGE	POLYESTER/POLYURETHANE	$\varnothing 1.09 \times 1$ NEW PIG CORP. #PAD210	1

RED BARN MACHINE	
TITLE MGB DRAIN TUBE	
DWG NO. RBE703A95-0508-00	REV 5C
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AS350, EC130	
SCALE 1:3	DATE 7/31/2012
SHEET 1 OF 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							